

Date: Thursday, 1/25/2007 10:21:00 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : NUT PLATE
 Job Number : 30446
 Estimate Number : 10316
 P.O. Number : *N/A* Part Number : D2680041
 This Issue : 1/25/2007 S.O. No. : *N/A* Drawing Number : D2680 REV B1
 Prsht Rev. : *NC* Project Number : *N/A*
 First Issue : *N/A* Type : SMALL /MED FAB Drawing Revision : B1
 Previous Run : 28935 Material : *N/A*
 Due Date : 2/20/2007 Qty: 50 Um: Each
 Written By : *[Signature]*
 Checked & Approved By : *[Signature]*
 Comment : Est: D 04.10.01 Added Steps 2-4, 7-8 : KJ/JLM
 Est Rev:E Now on WaterJet 06-10-12 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S16GA 1010/1025/A21/6aA SHEET



Comment: Qty.: 0.0138 sf(s)/Unit Total : 0.6878 sf(s)

1010/1025/A21/6aA SHEET .063" thk

Batch: *m9131*

ml 07-05-10

50

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2680

Dwg Rev: *B1*

Prog Rev: *B1*

ml 07-05-10

50

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



ml 07-05-10

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

50

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ml 07-05-10

counted 50

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Deburr

2-C'sink as per Dwg D2680

ml 07/05/17 x50

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/25/2007 10:21:00 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE

Job Number: 30446

Part Number: D2680041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M1103706



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

MF 07-05-22 (7)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 07-05-23

8.0

MS20426AD33

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 100.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	MS20426AD3-3	Rivet	

m1563 -

9.0

MS21069L4

Nutplate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	MS21069L4	Nut Plate	

m5865 x15 mx, m100152 x 35 mx

MF 07-05-23

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Nut Plate as per Dwg D2680

MF 07-05-24

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07-05-24

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/05/24 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: R Date: 07/05/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 1/25/2007 10:21:00 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: NUT PLATE

Job Number: 30446

Part Number: D2680041

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC21

FINAL INSPECTION/W/O RELEASE



50

Comment: FINAL INSPECTION/W/O RELEASE

D2680041/25

Job Completion



U 070525

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

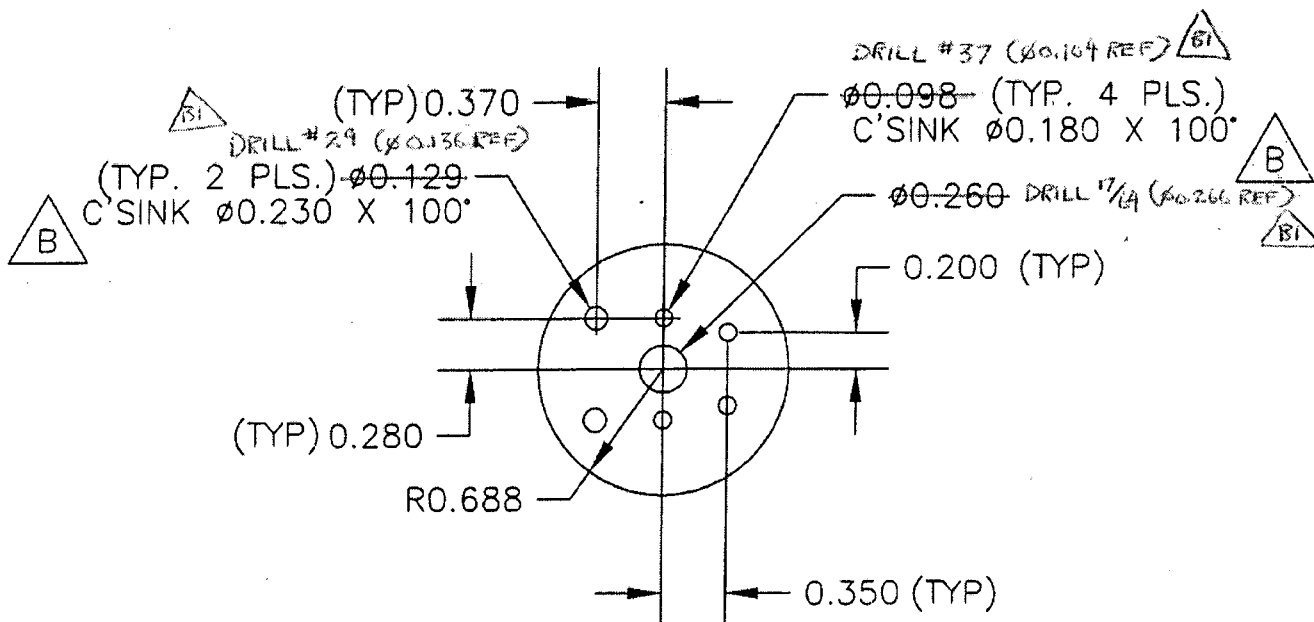
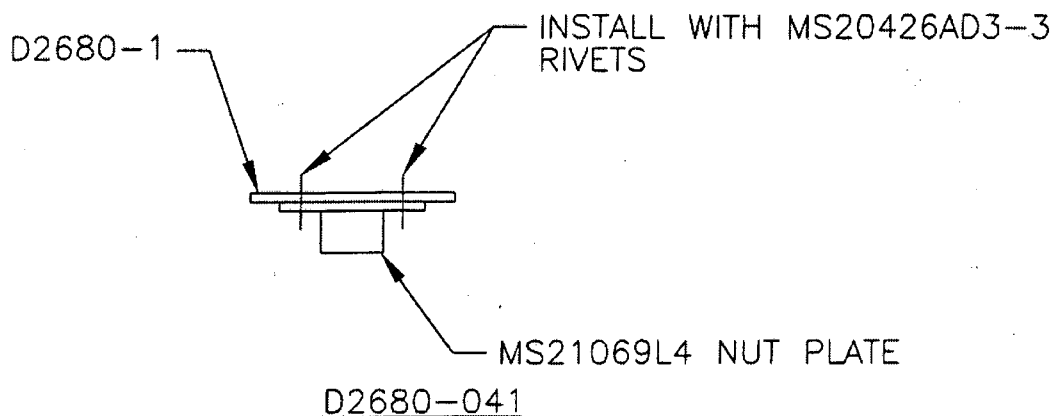
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY #	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED CP	APPROVED KE	DRAWING NO. D2680	REV. B SHEET 1 OF 1
DATE 98.12.14	TITLE NUT PLATE		SCALE 1:1
A	97.09.15	NEW ISSUE	
B	98.12.14	CHANGE C'SINKS (PER TSR A1041)	
BI	CP	04.11.04	CHANGE HOLES & FINISH

RELEASED
98.12.14 DS



MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.063 THICK (16 GAUGE)

GAD PLATE PRIOR TO INSTALLATION OF MS21069L4

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

(B1) POWDER COAT WHITE (4.35.2) PER DART QSI 005 4.3
D2680-1

NOTED
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30446

DART AEROSPACE LTD		Work Order: 30446
Description: Bearpaw Nut Plate		Part Number: D2680-041-1
Inspection Dwg: D2680 Rev: B1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\phi 0.104$	$+0.005-0.001$	0.104	✓		VERN	
B $\phi 0.266$	$+0.006-0.001$	0.266	✓		VERN	
C $\phi 0.136$	$+0.005-0.001$	0.136	✓		VERN	
D 0.370	$+1-0.010$	0.368	✓		VERN	
E 0.280	$+1-0.010$	0.279	✓		VERN	
F R0.688	$+1-0.010$	R0.688	✓		Radius Gauge	
G						
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: <i>M. J. M.</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 01.05.10	Date: 01.05.10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	KJ/RF	

